

# Work Order ID 116675

April-23-14 9:15:50 AM

**\*116675\***

Page 1

Item ID: D4542-7

Revision ID:

Item Name: Retainer, Inner

Start Date: 4/23/14

Start Qty: 10.00

**\*10\***

Required Date: 5/07/14

Req'd Qty: 10.00

**\*10\***

Reference:

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: ML5

Date: 14-04-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4542

E

100

0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

Memo

1- Cut as per dwg

Prog rev: F

Dwg rev: F

2- Deburr

0.00

10

0

Jm14-05-11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

Memo

0.00

10

0

Jm14-05-11



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Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

27

9-89

0.00

14/5/12

10

**\*120\***

QC

Memo

Quality Control

125

Chemical Conversion Coat per QSI005 4.1

0.00

**\*125\***

HandFinish

Memo

Hand Finishing

0.00

10 7/6/14-5/12

127

QC7-Inspect Chemical Conversion Coat

0.00

**\*127\***

QC

Memo

Quality Control

0.00

DAS

27

9-89

14/5/13

10

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Page 3

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Start Qty: 10.00

\*10\*

Required Date: 5/07/14

Req'd Qty: 10.00

\*10\*

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 81532 0.00

\*130\*

Packaging

Memo

0.00

Packaging

10X

14-5-13

DAS  
26  
9-89

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

MLJ

14-05-13

14-05-13

# Picklist Print

April-23-14 9:15:53 AM

Page 1

Work Order ID: 116675

**\*116675\***

Parent Item: D4542-7

**\*D4542-7\***

Parent Item Name: Retainer, Inner

Start Date: 4/23/14

Required Date: 5/07/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B  
12.02.24 as per dwg revA DD verf:EC IPP REV:C 12.05.08 as  
per dwg revB DD verf:EC IPP REV:D 12.08.08 AS PER DWG  
REV.C DD VERF:EC IPP REV:E 13.04.23 as per dwg revD DD  
verf:JLM

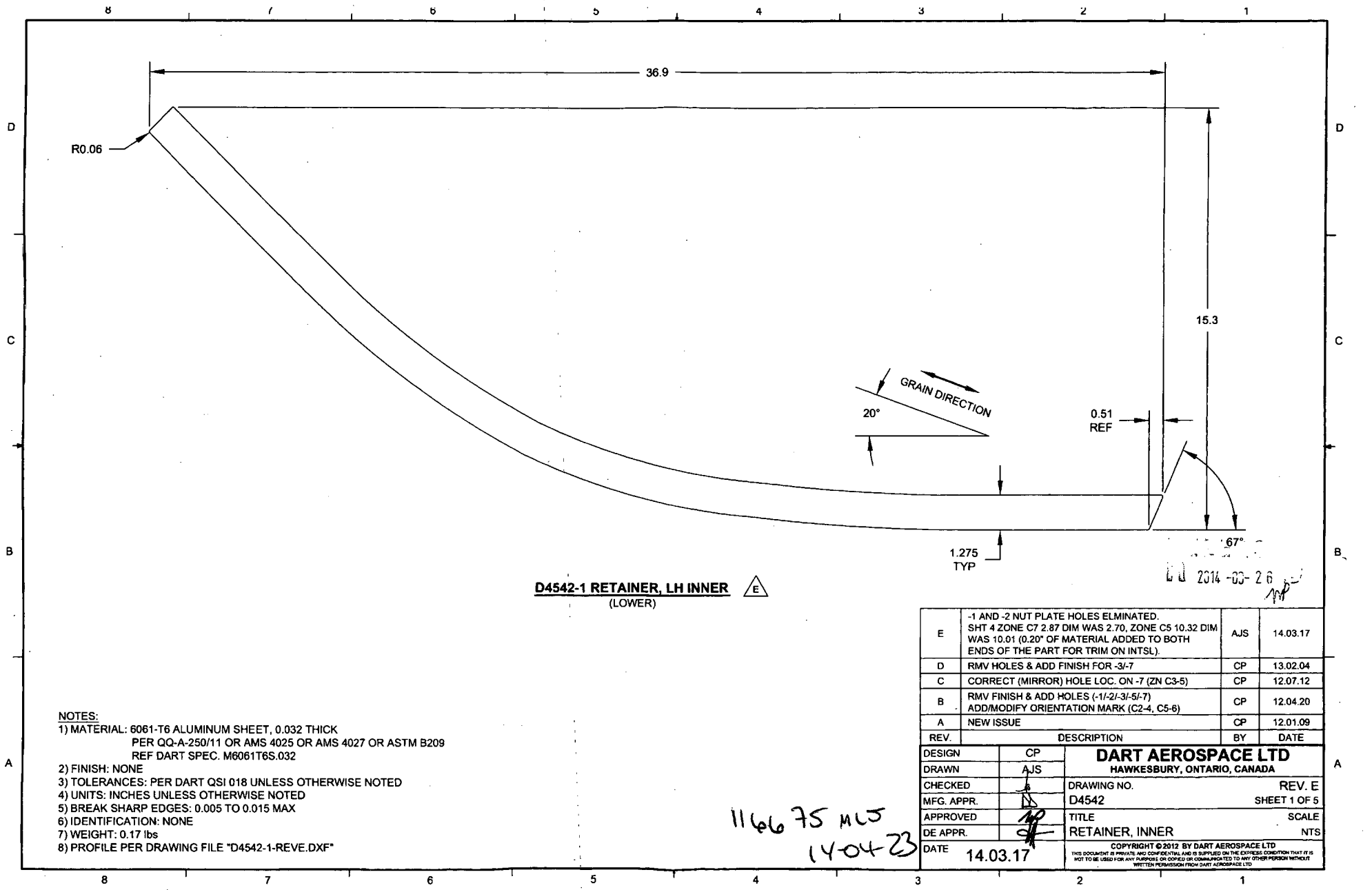
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No			sf	249.7232		3			
*M6061T6S 032*										**		Jm 14-05-11	
6061-T6 Sheet 0.032"													

Location	Loc Qty	Loc Code
MAT021	249.72317	
123483	8.57	
m125822	17	
m127272	119.43317	
m128054	104.72	

128054

## FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	
B	12.09.26	Dimensions updated per Dwg Rev C	KJ	
C	13.05.08	Dimensions updated per Dwg Rev D	KJ	



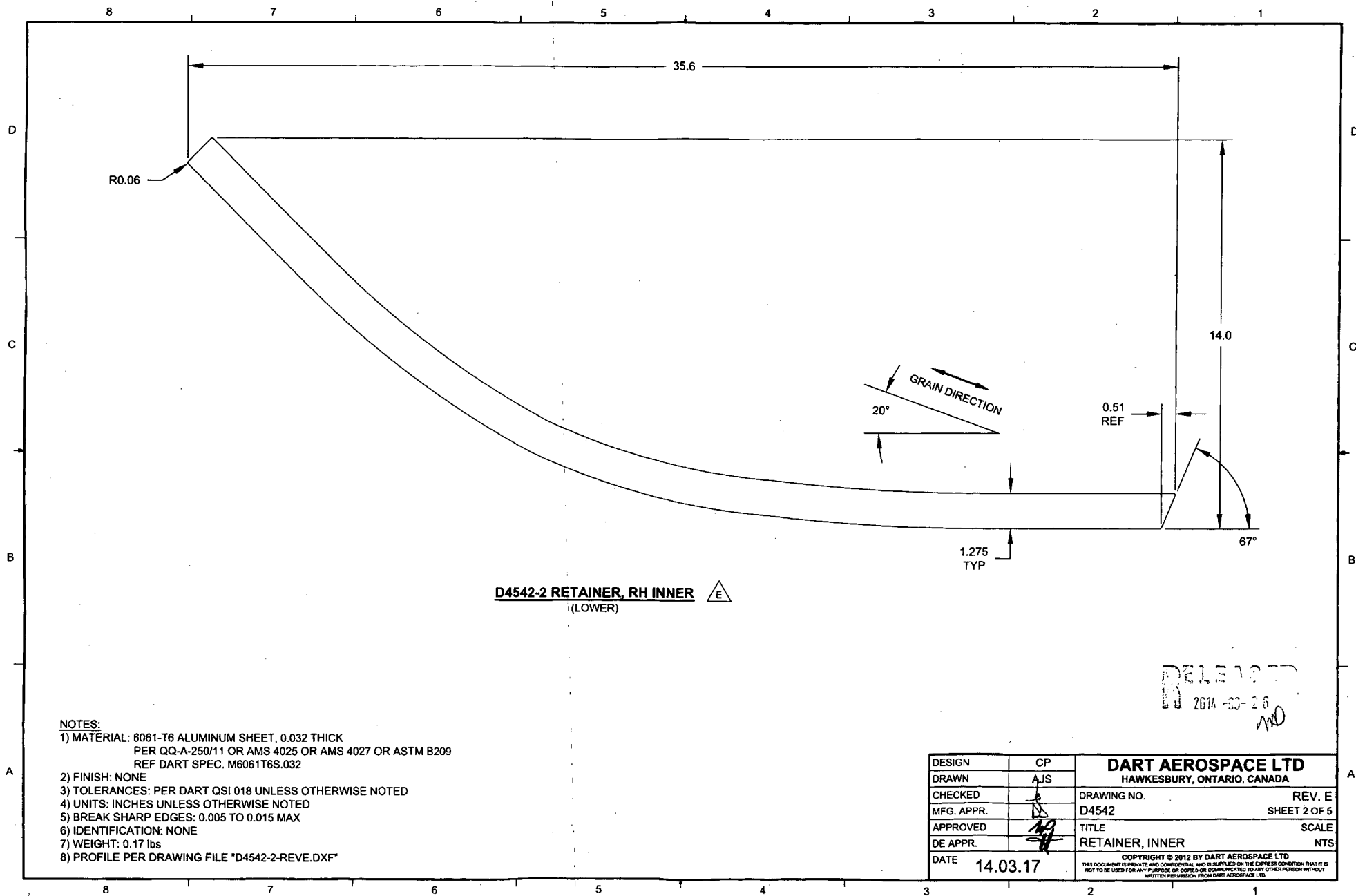
**D4542-1 RETAINER, LH INNER** E  
(LOWER)

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs
- 8) PROFILE PER DRAWING FILE "D4542-1-REVE.DXF"

E	-1 AND -2 NUT PLATE HOLES ELIMINATED. SHT 4 ZONE C7 2.87 DIM WAS 2.70, ZONE C5 10.32 DIM WAS 10.01 (0.20" OF MATERIAL ADDED TO BOTH ENDS OF THE PART FOR TRIM ON INTSL).	AJS	14.03.17
D	RMV HOLES & ADD FINISH FOR -3/-7	CP	13.02.04
C	CORRECT (MIRROR) HOLE LOC. ON -7 (ZN C3-5)	CP	12.07.12
B	RMV FINISH & ADD HOLES (-1/-2/-3/-5/-7) ADD/MODIFY ORIENTATION MARK (C2-4, C5-6)	CP	12.04.20
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. REV. E D4542 SHEET 1 OF 5  TITLE SCALE RETAINER, INNER NTS  <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.03.17		

116675 MJS  
14-04-23



**D4542-2 RETAINER, RH INNER** E  
(LOWER)

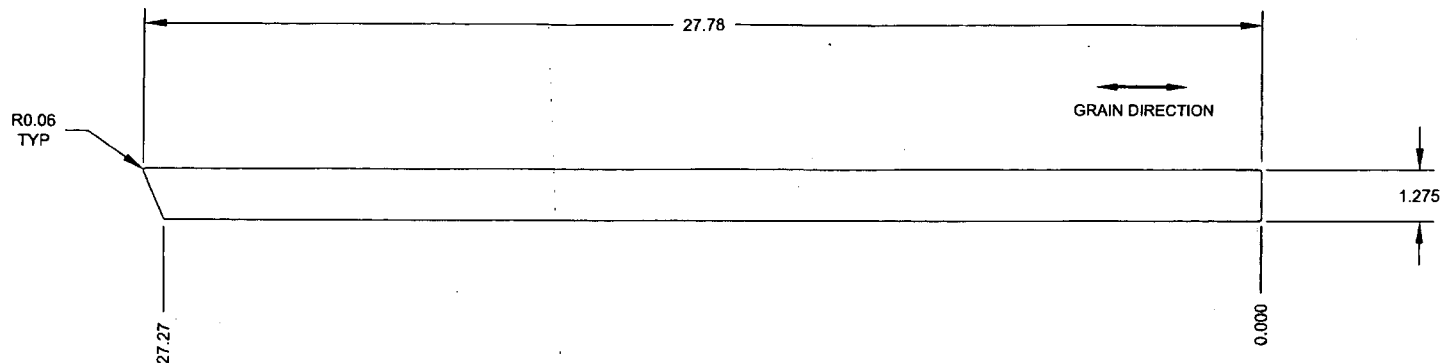
**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs
- 8) PROFILE PER DRAWING FILE "D4542-2-REVE.DXF"

RELEASED  
2016-03-26  
MD

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MFG. APPR.	<i>[Signature]</i>	D4542	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER, INNER	NTS
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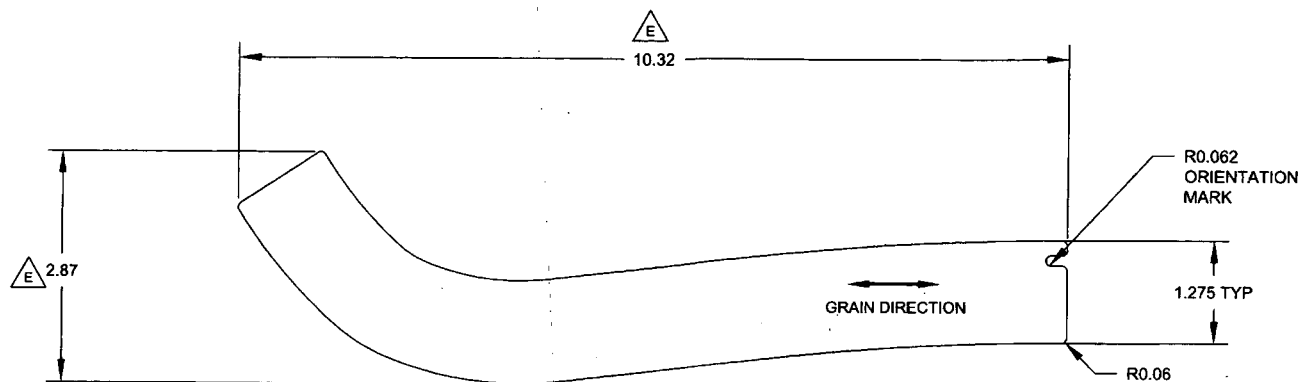


**D4542-3 RETAINER, INNER**  
(SIDE)

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.11 lbs
- 8) PROFILE PER DRAWING FILE "D4542-3-REVE.DXF"

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MFG. APPR.		D4542	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
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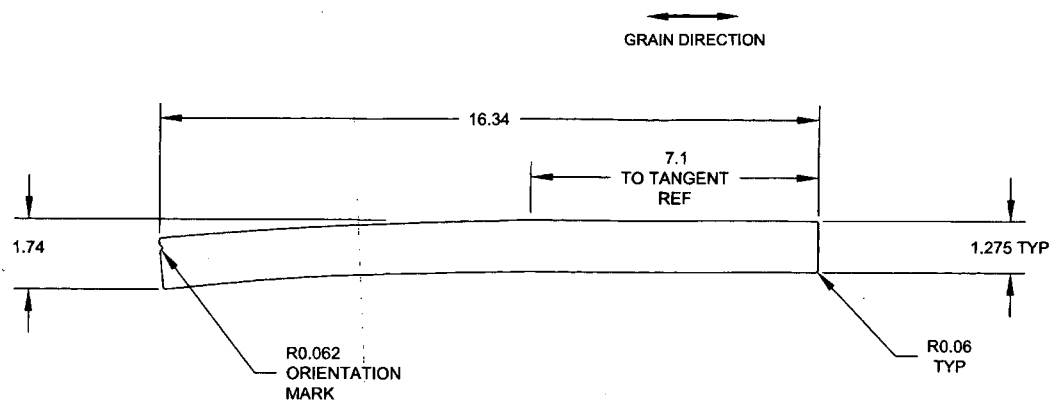


**D4542-5 RETAINER, INNER**  
(TOP CORNER)

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REVE.DXF"

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MFG. APPR.	<i>[Signature]</i>	D4542	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER, INNER	NTS
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**D4542-7 RETAINER, INNER**  
(TOP)

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs
- 8) PROFILE PER DRAWING FILE "D4542-7-REVE.DXF"

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MFG. APPR.	<i>[Signature]</i>	D4542	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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